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Canada

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D4017-041

Job Sheet 203689



Part No: D4017-041

Job Qty: 1 pcs

Part Name: Short Basket Base Assembly (350)



Part Weight: 0 lbs

Job Created: 11/25/19

Due Date: 12/27/19

Type: Stock

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description: SIOP

Note: DWG D4020 REV A SHEET 4, D4017 REV F SHEETS 1,2,3,4 IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 10.11.04 added pressure wash DD verf:EC IPP REV:F 12.07.24 AS PER DWG REV.D DD VERF:EC IPP REV:G 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	12/27/19		0.00	14.93	Large Fab - 1		MAL
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	12/27/19		0.00	0.00	QC 9 - 10		DAS 24 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
					0.00	0.00	QC 5 - 24		DAS 24 9-89
							QC 5 - 3		
							QC 5 - 43		



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Container No: S244790



Part: D4017-041

Job No: 203689

Serial No/Batch: S244790

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/08/20

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						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
125	Handfinish - 2-1 Pressure-B4B	1 pcs	12/27/19	0.00 0.17	Handfinish - 2 - 1 - B4B		ML 20-1-9
					Handfinish - 2 - 2 - B4B		
					Handfinish - 2 - 3 - B4B		
					Handfinish - 2 - 4 - B4B		
130	Powdercoat - 2 White GI(S)-B4B	1 pcs	12/27/19	0.00 0.68	Powdercoat - 1 - B4B		
					Powdercoat - 2 - B4B		
					Powdercoat - 3 - B4B		DK 20-01-9.
					Powdercoat - 4 - B4B		
140	QC 3	1 pcs	12/27/19	0.00 0.00	QC 3 - 10		
					QC 3 - 13		
					QC 3 - 15		ML 20-1-9
					QC 3 - 17		
					QC 3 - 18		
					QC 3 - 2		
					QC 3 - 28		
					QC 3 - 3		
					QC 3 - 30		
					QC 3 - 34		
					QC 3 - 36		
					QC 3 - 41		
					QC 3 - 51		
					QC 3 - 58		
					QC 3 - 59		
					QC 3 - 68		
					QC 3 - 9		
					QC 3 - 40		
					QC 3 - 19		
					QC 3 - 43		
					QC 3 - 24		
					QC 3 - 61		
					QC 3 - 81		
150	Handfinish - 4-1-Assembly-B4B	1 pcs	12/27/19	0.00 0.40	Handfinish - 4 - 1 - B4B		ML 20-1-9
					Handfinish - 4 - 10 - B4B		
					Handfinish - 4 - 11 - B4B		
					Handfinish - 4 - 12 - B4B		
					Handfinish - 4 - 13 - B4B		
					Handfinish - 4 - 14 - B4B		
					Handfinish - 4 - 15 - B4B		
					Handfinish - 4 - 2 - B4B		

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9-89

						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
160 QC 5	1 pcs	12/27/19	0.00	0.00		QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	DAS JAN 09 2020 68
						QC 5 - 9	9-88
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
170 Packaging 3-1 - Stock - B4B	1 pcs	12/27/19	0.00	0.00		Packaging 3 - 1 - B4B	SL 20-1-10
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	

				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180	QC 21 - SA	1	12/27/19	0.00 0.00	QC 21 - SA - 21 DAS
		pcs			QC 21 - SA - 70 21
					QC 21 - SA - 53 53

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Part Op **100** - (Weld per dwg A/R S.S. rod Batch **41139023**, 1- assemble ribs , weld as per dwg D4017 using DT9610B 2- Cut Descriptions: mesh as per dwg D4020-3 3- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 4- weld hinge (3) and Mounting brackets as per dwg D4017 5- Weld D4672-3 blanking plates as per dwg

110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

125 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)

130 - (White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel), 1- Plug holes and mask only interior of hinge (3) prior to powder coat

140 - (QC3- Inspect Part Finish)

150 - (Assemble as per dwg)

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

N4# 013642

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5214321
D3913-15 ✓	Wide Handle Plate	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5211077
D3916-041 ✓	Rib Assembly	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5236847
D3916-5 ✓	Light Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5239761
D4016-1 ✓	Hinge Half, Base	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	5231789
D4017-1 ✓	Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5188068
D4017-3 ✓	Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5190504
D4017-5 ✓	Hinge Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5127736
D4017-7 ✓	Rib	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	5233314
D4017-9 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5231158
D4020-11 ✓	End Mesh, Basket	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5231922
D4021-1 ✓	Handle Plate	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	5242694
D4034-041 ✓	Aft Upper Rib Assembly	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5238687
D4034-043 ✓	Fwd Upper Rib Assembly	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5240031
D4672-3 ✓	Blanking Plate	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5192444
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	5235320
AN3-10A	BOLT	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5186435
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5241506
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5196544
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5218152
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5034411
NAS1149DN832J	Washer	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5216347
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	5218152

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	61	0
	D3913-15	1	31	0
	D3916-041	2	12	0
	D3916-5	1	9	0
	D4016-1	3	55	0
	D4017-1	1	4	0
	D4017-3	1	8	0
	D4017-5	1	3	0
	D4017-7	3	64	0
	D4017-9	2	24	0
	D4020-11	2	6	0
	D4021-1	3	27	0
	D4034-041	1	4	0
	D4034-043	1	7	0
	D4672-3	2	5	0
	M304EX0.75-16F	32	490	0
	AN3-10A	6	76	0
150-Handfinish - 4-1-Assembly-B4B	D2931	2	607	0
	D4021-5	2	13	0
	MS20600-AD4W3	2	172	0
	MS21042L3	6	1,873	0
	NAS1149DN832J	2	422	0
	NAS1149F0332P	12	4,145	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is		DEPARTMENT/PROCESS ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause		FAULT CATEGORY			
☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			